



Dart Aerospace Ltd.
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D2432

Job Sheet 195562



Part No: D2432

Job Qty: 24 pcs

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 7/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	24 pcs	7/4/19	7/4/19	0.00	6.19	Waterjet - Omax		2/19/07/09
130	HAAS 4 Axis - B4B	24 pcs	7/4/19	7/4/19	0.36	30.04	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	24 pcs	7/4/19	7/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150 QC 8	24 pcs	7/4/19	0.00	0.00	QC 8 - 12	mk 19/07/22
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					160 Packaging 3-1 - Stock - B4B	
Packaging 3 - 2 - B4B						
Packaging 3 - 3 - B4B						
Packaging 3 - 4 - B4B						
Packaging 3 - 5 - B4B						
Packaging 3 - 6 - B4B						
Packaging 3 - 7 - B4B						
Packaging 3 - 8 - B4B						
Packaging 3 - 9 - B4B						
Packaging 3 - 10 - B4B						
Packaging 3 - 11 - B4B						
Packaging 3 - 12 - B4B						
Packaging 3 - 13 - B4B						
Packaging 3 - 14 - B4B						
Packaging 3 - 15 - B4B						
Packaging 3 - 16 - B4B						
Packaging 3 - 17 - B4B						
Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B						
Packaging 3 - 20 - B4B						
Packaging 3 - 21 - B4B						
Packaging 3 - 22 - B4B						
Packaging 3 - 23 - B4B						
Packaging 3 - 24 - B4B						
Packaging 3 - 25 - B4B						
Packaging 3 - 26 - B4B						

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					Packaging 3 - 27 - B4B			
					Packaging 3 - 28 - B4B			
					Packaging 3 - 29 - B4B			
					Packaging 3 - 30 - B4B			
					Packaging 3 - 31 - B4B			
					Packaging 3 - 32 - B4B			
					Packaging 3 - 33 - B4B			
					Packaging 3 - 34 - B4B			
					Packaging 3 - 35 - B4B			
					Packaging 3 - 36 - B4B			
170	QC 21 - SA	24 pcs	7/4/19	0.00 0.00	QC 21 - SA - 21			
					QC 21 - SA - 70	21		
					QC 21 - SA - 53	5-85 JUL 23 2019		
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	120-Waterjet - Omax - 1					
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
120-Waterjet - Omax - 1	MUHMWB10	89	1,021	0				
Part Specifications								
Specifications could not be found.								

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DART AEROSPACE LTD		Work Order: 195562
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.06 x 45°	✓		Ver.	
B	0.200	+/-0.030	0.200	✓		D.G.	
C	0.25 x 45°	+/-0.030	0.250	✓		Ver.	
D	R0.250	+/-0.030	0.250	✓		R.G.	
E	0.250	+/-0.010	0.255	✓		Ver	
F	0.625	+/-0.030	0.630	✓		Ver	
G	0.385	+0.030/-0.010	0.385	✓		Ver	
H	0.950	+/-0.030	0.960	✓		Ver	
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	0.260	✓		G.P.	
K	Ø0.93	+/-0.030	0.930	✓		Ver.	
L	0.30	+0.030/-0.000	0.308	✓		D.G.	
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	✓		Ver	
O	0.38	+/-0.030	0.380	✓		Ver	
P							
Q							
R							
S							
T							
U							
V							

Measured by: DAS 52	Audited by: [Signature]	Preliminary Approval:
Date: 19/07/20	Date: 19/07/22	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S196987



Part: D2432

Job No: 195562

Serial No/Batch: S196987

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 07/10/19